



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2580-1
Job Sheet 168472



Part No: D2580-1

Job Qty: 12 ea

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/17

Job Tracking No:

Due Date: 12/1/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		11/29/17	0.00	0.00	Start Up Skidtubes		
100	Skidtubes	12 pcs		11/30/17	0.00	11.11	Skidtubes		
101	QC	12 pcs		11/30/17	0.00	0.00	QC6		
110	HandFinish	12 pcs		11/30/17	0.00	5.00	HandFinish1		
120	QC	12 pcs		11/30/17	0.00	0.00	QC7		
125	Skidtubes	12 pcs		12/1/17	0.00	11.11	Skidtubes		
130	QC	12 pcs		12/1/17	0.00	0.00	QC5		
140	Packaging	12 pcs		12/1/17	0.00	0.00	Packaging3		
150	QC21-SA	12 Ea		12/1/17	0.00	0.00	QC21		

Part Op 100 - 1. Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes to 0.508"
Descriptions: as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit

inspection saddles on FWD & AFT saddle holes using DT9916.

125 - 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: 138 654 Sikaflex expire date: 18-04-21 Start time and date: 17-12-01 bond for 12hrs

140 - LOCATION : LG002

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-1-190 <u>F159719</u>	<u>12</u>	63	0	0
	D2596 <u>S 013506</u>	12	4	0	0

Part Specifications

Specifications could not be found.

Plex 11/15/17 9:01 AM dart.poulin.mario

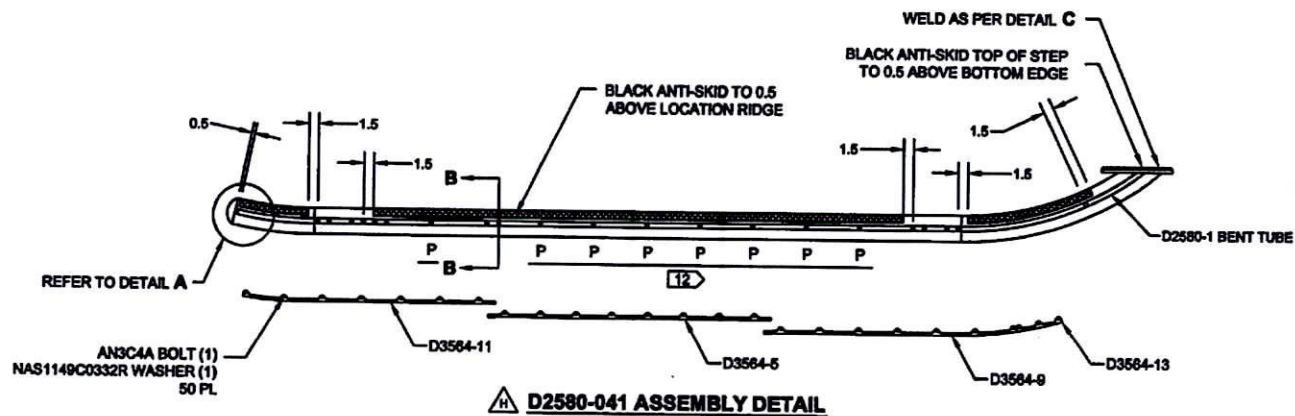
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

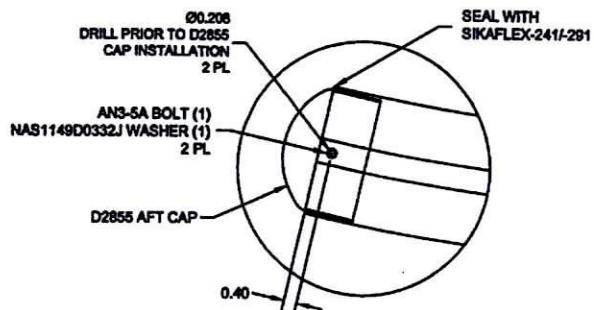
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Work Order update only ☐

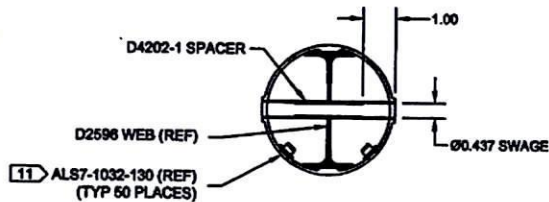
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Material ☐ Engineering ☐ Quality ☐ Other ☐																																																																																													
Date : _____		Step #: _____		QT _____																																																																																													
Description Work Order Deviation PART NO: D2580-1 Revision: Operation: Change No: Start up Operation																																																																																																	
Root Cause <table border="0" style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td><td>Pressure/Forced</td><td>☐</td><td>Temper</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td><td>Centre Not Concentric</td><td>☐</td><td>BOM/R</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td><td>Cracks</td><td>☐</td><td>Broken,</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspect</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td><td>Cuffs</td><td>☐</td><td>Contan</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td><td>Crushing</td><td>☐</td><td>Counte</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td><td>Heat Treat</td><td>☐</td><td>Cut To</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td><td>Wave/Twist in Tube</td><td>☐</td><td>Instruc</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td><td colspan="4" rowspan="2">OTHER : _____</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> 205 Bent Tube S012315 DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com						Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temper	☐	Design	☐	Operator	☐	Bending	☐	Set-up	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/R	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken,	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspect	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contan	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Counte	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut To	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instruc	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____				Misidentified	☐	Past Due	☐
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DETAIL A
SCALE 5X

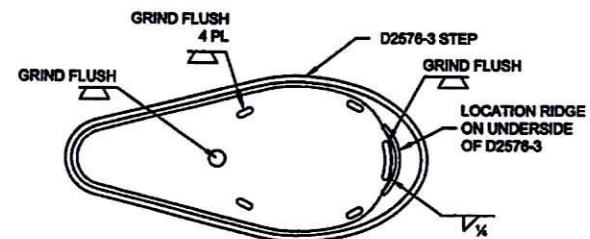


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

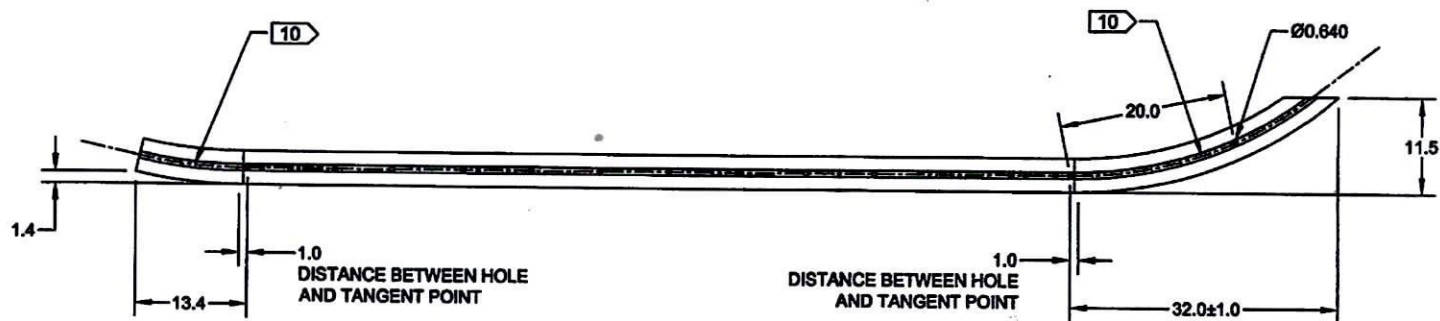
DETAIL C
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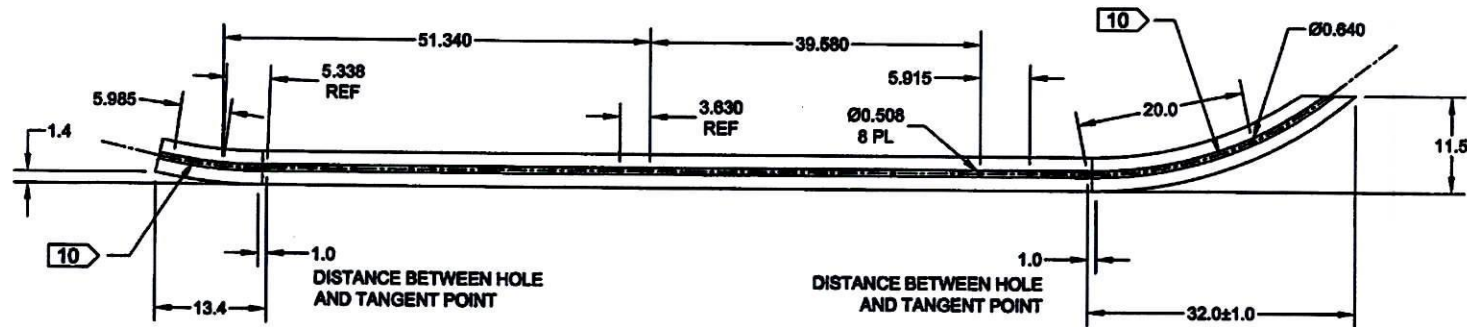
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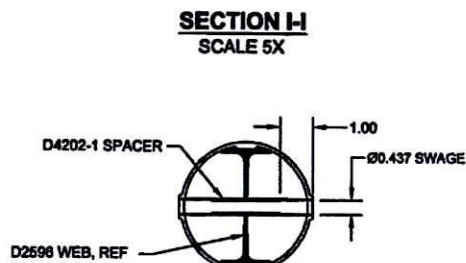
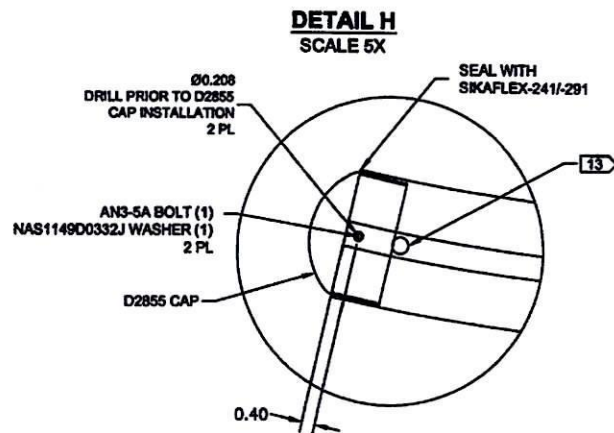
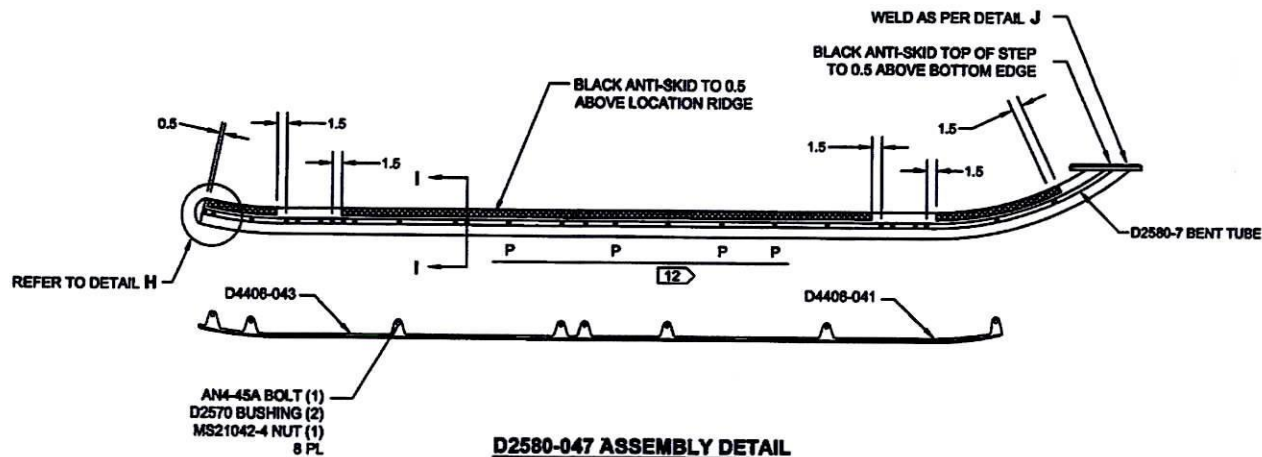
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D2580-5 BENT TUBE
(MAKE FROM D2680-101 TUBE)

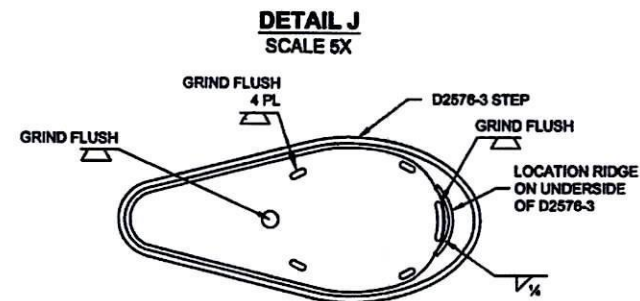
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AFTER DRILLING AND BENDING ASSEMBLY
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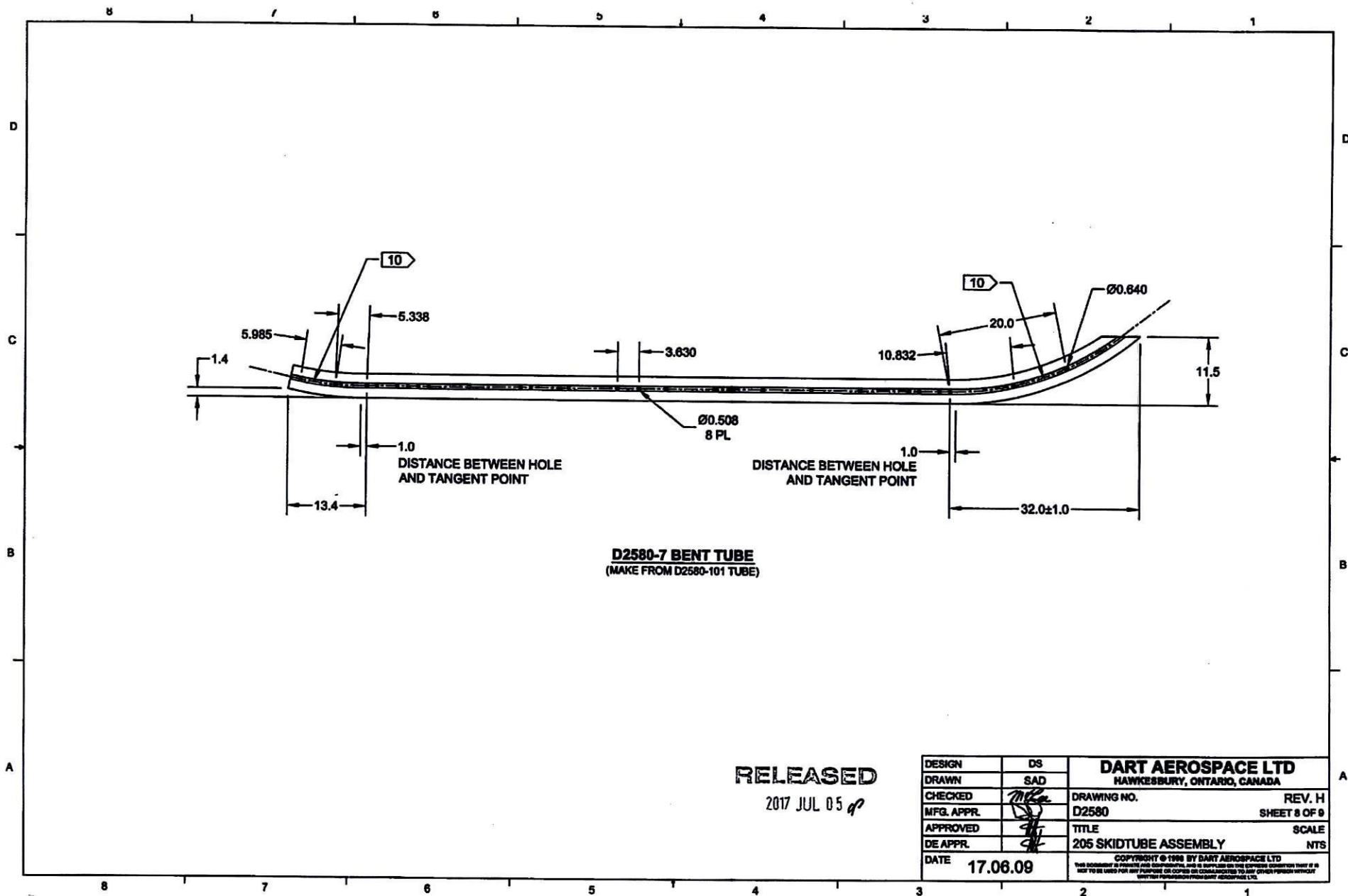
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



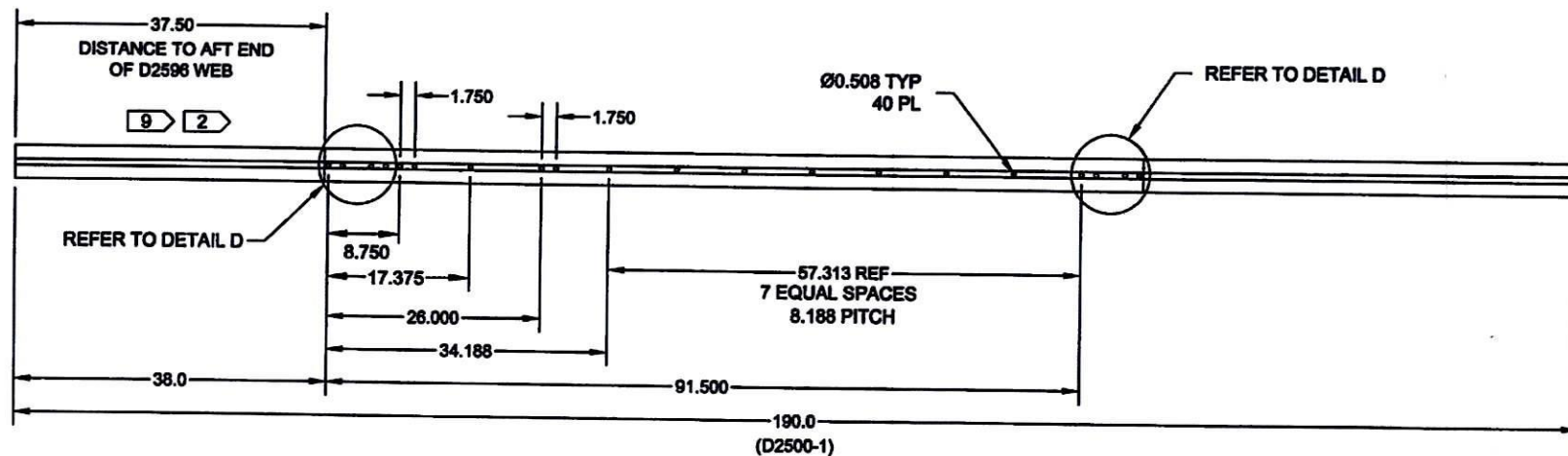
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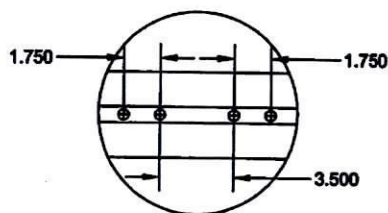
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D2580-101 TUBE



DETAIL D
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